



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-604-041
Job Sheet 198753



Part No: D350-604-041

Job Qty: 1 pcs

Part Name: Rear Locker Extender



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Due Date: 9/13/19 *10/09/2019*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D350-604-041 REV C, D2273 REV M IPP Rev:Q 03.12.01 Reformat KJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM IPP REV:X 17.01.12 AS PER CHG010 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	1 pcs	9/13/19	9/13/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
120	Packaging 2-1 - Receive - B4B	1 pcs	9/13/19	9/13/19	0.00	0.00	Packaging 2 - 1 - B4B		<i>DP</i> OCT 16 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		<i>DP</i> 16 2019 OCT 16 2019
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S222784



Part: D350-604-041

Job No: 198753

Serial No/Batch: S222784

Revision: C/M

Inspector:

Exp Date:

Instructions: TC STC SH90-4 Issue 4, FAA STC SR00463N

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				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130	QC 6	1 pcs	9/13/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
140	Small Fab - 2 - B4B	1 pcs	9/13/19	0.00 0.00	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
150	QC 5	1 pcs	9/13/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
155	Packaging 1-1 - Pick Kit - B4B	1 pcs	9/13/19	0.00 0.00	Packaging 1 - 1 - B4B
					Packaging 1 - 2 - B4B
					Packaging 1 - 3 - B4B
					Packaging 1 - 4 - B4B
					Packaging 1 - 5 - B4B
					Packaging 1 - 6 - B4B
					Packaging 1 - 7 - B4B
					Packaging 1 - 8 - B4B
					Packaging 1 - 9 - B4B
					Packaging 1 - 10 - B4B
					Packaging 1 - 11 - B4B
					Packaging 1 - 12 - B4B
					Packaging 1 - 13 - B4B
					Packaging 1 - 14 - B4B
					Packaging 1 - 15 - B4B
					Packaging 1 - 16 - B4B

				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
158	QC 4	1 pcs	9/13/19	0.00 0.00	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
160	Packaging 3-1 - Stock - B4B	1 pcs	9/13/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

NOV 6 1 2019

 DAS
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NOV 0 1 2019

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NOV 0 1 2019

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
165 DC - 1 - B4B	1 pcs	9/13/19	0.00 0.00	DC - 1 - B4B	21 NOV 01 2019
				DC - 2 - B4B	9-35
170 QC 21 - FG	1 pcs	9/13/19	0.00 0.00	QC 21 - FG - 21	DAG
				QC 21 - FG - 70	21 NOV 01 2019
				QC 21 - FG - 53	9-35

Part Op 110 - Purchasing - Issue P/O: ~~H604038~~ Description: D350-604-041 Rear locker extender. Manufacture as per dwg
 Descriptions: D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required. ***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***

120 - Receive & Inspect for Damage & Mat'l Certs - Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached. ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***

130 - QC6- All purchased or subcontracted products - Check hole locations to template. DT 8824 Check process sheet and audit.

140 - Small Fab - 1- INSTALL DECALS AS PER DWG (D2728-1)

150 - QC5- Inspect part completeness to step on W/O

155 - Pick Kit ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***

158 - QC4- 100% Inspect kits for completeness

160 - Identify as per dwg & Stock Location:

165 - Photocopy bluefile and create labels per PPP D350-604-041 CHG0010

170 - QC21- Final Inspection - Work Order Release

x1 Plus aug 13 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-604-041P	Rear Locker Extender	1 Ea (1 ea)	110-Purchasing	5222783
D2268	Placard	1 pcs (1 ea)	140-Small Fab - 2 - B4B	5201795
D2269	Placard	1 pcs (1 ea)	155-Packaging 1-1 - Pick Kit - B4B	5184247
D5062-041	Bracket Assembly	1 pcs (1 ea)	155-Packaging 1-1 - Pick Kit - B4B	5213031

Job Allocations

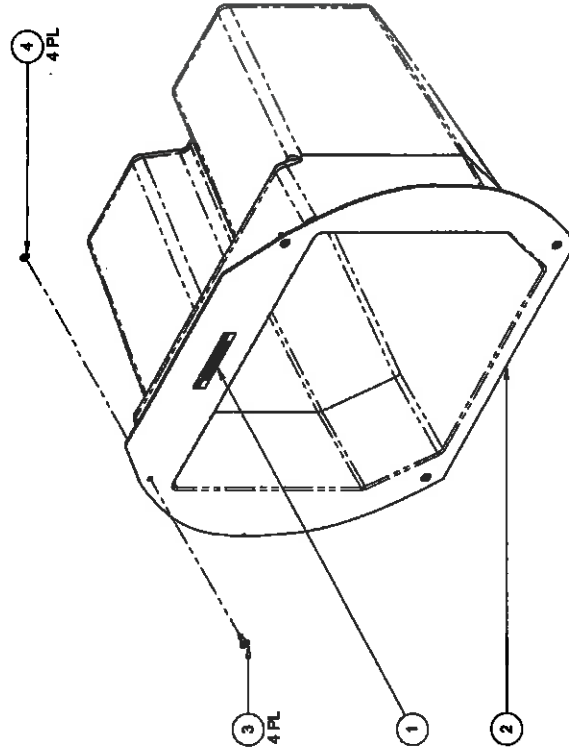
Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D350-604-041P	1	0	0
140-Small Fab - 2 - B4B	D2268	1	21	0
155-Packaging 1-1 - Pick Kit - B4B	D2269	1	19	0
	D5062-041	1	2	0

Part Specifications

Specifications could not be found.

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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
2	1	D2288	PLACARD
3	1	D2273	REAR LOCKER EXTENDER
4	4	2600-S	CAM LOCK STUD
5	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 5.5 TO 7.5 lbs
 - 8) INSTALL D2288 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 19875345
19-08-06

DEL ASSY
2014-01-06

REV.	DESCRIPTION	BY	DATE
C	REMOVE D2726-1, D2728-1 DECALS (ZN C5-1) REWORK D2726-1, D2728-1 WEIGHT INCORPORATE (QSI 018) (ZN D25-1) UPDATE DWG TO CURRENT STANDARDS, ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C5-1), ADD D2728-1 (ZN C5-1).	ML	13.12.07
B		DC	12.02.07
A	NEW ISSUE	CP	02.04.01
DESIGN	DW	ML	DATE
DRAWN			
CHECKED	AP		
IMFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS		
DATE	14.01.02		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D350-604-041**
REV. C
SHEET 1 OF 1
SCALE
NTS
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ALL RIGHTS RESERVED
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TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

D2273 REAR LOCKER EXTENDER

TABLE 3

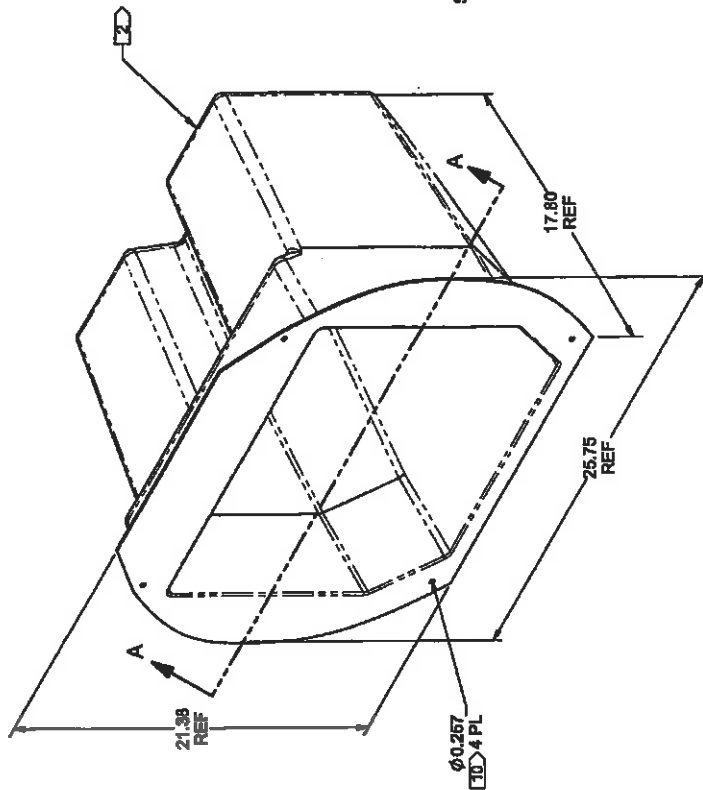
MATERIAL USED	DESCRIPTION
GELCOAT	55X3535 WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7734
PRIMER	TEMPO 4600-PB-23G (GREEN)

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.5-7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9806. OPEN HOLES TO Ø0.257
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

RELEASED
R 2017-01-11
E2117-501

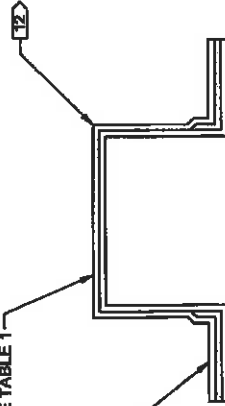
APPROVED



SEE TABLE 1

SEE TABLE 2

SECTION A-A



M	CHANGE GELCOAT TO 55X3535 WHITE GELCOAT, REMOVE PAINT FINISH OPTION (NOTE 2)	DB	16.06.19
L	ADD PAINT OPTION (NOR 16-5408)	CP	15.10.10
K	LAYUP AND MATL PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA PR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2336P/AMK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.16
G	ADD MANUFACTURING OPTION B, ZN BE-1	DC	12.08.08
F	PRIMER LE 3404-91E 1175-3 WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 844WDS GELCOAT TO 2336P/AMK745 GELCOAT, ZN A7-1, UPDATED DWG TO CURRENT STANDARDS	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.91
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.93
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	DB		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	16.05.19		

DART AEROSPACE LTD

HARRISBURG, ONTARIO, CANADA

DRAWING NO.

D2273

TITLE

350 REAR LOCKER EXTENDER NTS

SCALE

SHEET 1 OF 1

REV. M

Entered: _____ Date: _____

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:	QTY Affected :		MRB (QS1042)							
Description Work Order Deviation				Disposition							
				Completed By							
				Lead hand / Supervisor							
				QC / QA Coordinator							
Root Cause		FAULT CATEGORY									
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐							
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐							
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐							
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐							
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐							
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐							
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐								
Human Factors ☐	Other/Details:										



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044252



Supplier: FDC001-VC
FDC Composites Inc.
45 chemin de L'Aéroport, Local 26
St-Jean-sur-Richelieu
QC
J3B 7B5 Canada
Phone: 450-357-1344 ext303
Fax: 450-357-1194

PO No: POHB044252
PO Date: 8/13/19
Due Date: 10/7/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198751	D350-604-041P			Rear Locker Extender	Firmed	-	10/7/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
2	198752	D350-604-041P			Rear Locker Extender	Firmed	-	10/8/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
3	198753	D350-604-041P			Rear Locker Extender	Firmed	-	10/9/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
4	198754	D350-604-041P			Rear Locker Extender	Firmed	-	10/10/19	1 Ea	0 Ea	1 Ea	\$835.00/Ea	\$835.00
Grand Total:												\$3,340.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 8/13/19 10:46 AM dart.lussier.patrick

FDC Composites inc.

45 chemin de l'Aéroport
Suite 26
Saint-Jean-sur-Richelieu, Québec J3B 7B5
Canada
Tel: (450) 357-1344
Fax: (450) 357-1194

Packing Slip

Packing Slip No.: 10341
Date: 2019-10-11
Page: 1

Sold to: DAE-CAD Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada	Ship to: DAE-CAD Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada
Order No.: HB044252	Sold By:
Shipped By:	Ship Date:
Tracking No.:	

Item No.	Unit	Description	Quantity
DAE001	Chaque	Rear Locker Extender, 350 PO Item: HB044252 FDC ID: DAE001-171 2019-10-09 FDC ID: DAE001-168 2019-09-12 FDC ID: DAE001-169 2019-09-13 FDC ID: DAE001-174 2019-10-09	4
Comment:			

RECEIVED
OCT 15 2019
DART AEROSPACE LTD.



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: HB044252

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198751	DAE001-171	2019-10-09
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198752	DAE001-168	2019-09-12
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198753	DAE001-169	2019-09-13
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	198754	DAE001-174	2019-10-09

DAS
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9-89

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:

Marjorie Geoffrion
Marjorie Geoffrion, Quality Inspector

Date: 2019-10-10